

DIANAMIC® SUPERABRASIVE PARTICLE SIZE REFERENCE CHART

Technical Reference Data & Manufacturing Specifications

MESH SIZES

MESH SIZE	NOMINAL SIZE (INCHES)	FEPA** SIZE	OFFSET ALLOWANCE	APPLICATION
16/18	.047"	1181	.049"	Extra Heavy Stock Removal
18/20	.040"	1001	.043"	Extra Heavy Stock Removal
20/25	.034"	851	.036"	Extra Heavy Stock Removal
20/30	.034"	852	.036"	Extra Heavy Stock Removal
25/30	.028"	711	.030"	Very Heavy Stock Removal
30/40	.023"	601	.025"	Very Heavy Stock Removal
40/50	.017"	437	.018"	Heavy Stock Removal
50/60	.012"	301	.013"	Coarse Roughing
60/70	.010"	251	.011"	Coarse Roughing
60/80	.010"	252	.0105"	Coarse Roughing
80/100	.007"	181	.0075"	General Purpose Semi-Rough
100/120	.006"	151	.0063"	General Purpose Semi-Rough
120/140	.005"	126	.0053"	General Purpose
140/170	.004"	107	.0043"	General Purpose
170/200	.0036"	91	.0038"	Semi-Finish
200/230	.003"	76	.0032"	Semi-Finish
230/270	.0025"	64	.0027"	Semi-Finish
270/325	.0022"	54	.0024"	Finish
325/400	.0018"	46	.0019"	Finish
400/500	.0016"	-	.0017"	Fine Finish
500/600	.0012"	-	.0013"	Fine Finish

MICRON SIZES

MICRON SIZE	APPROX. GRIT EQUIVALENT	SIZE RANGE (MM)	SIZE (INCHES)	APPLICATION
45	400/500	40-50	.0018"	Fine Finishing
35	500/600	30-40	.0014"	Fine Finishing
30	800	25-35	.0012"	Very Fine Finishing
15	1000	8-22	.0006"	Very Fine Finishing
9	1500	6-13	.00035"	Very Fine Finishing
6	1800	4-8	.00024"	Extremely Fine Finishing
3	2100	2-4	.00012"	Extremely Fine Finishing

* 1 micron = .0000395" • ** FEPA Standard for Superabrasive Grain Sizes 1997

ENGINEERING CALCULATION & TOOLING NOTES

Male Radius Subtract: $Precoat\ Substrate\ Dimension = Target\ Finish\ Size - Particle\ Size\ Offset\ Allowance$

Female Radius Add: $Precoat\ Substrate\ Dimension = Target\ Finish\ Size + Particle\ Size\ Offset\ Allowance$

- **Custom Formulations:** Non-standard Diamond/cBN Mesh & Micron sizes (scalped, halved, quartered, or custom micronized distributions) available via special order.
- **Material Availability:** Dimensions apply to standard listed configurations. Supplied in Synthetic/Natural diamond or cBN.

Manufactured in Troy, Michigan USA with 100% US labor and globally sourced materials.

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